

Work Order ID 82736

April-05-12 12:57:14 PM

82736

Page 1

Item ID: D3256-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Panel

Stop ***NS2***

Start Date: 05/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/05 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3256	D								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3256

Dwg Rev: B

Prog Rev: D

2-Deburr if necessary

304 0.032

1312-4-42

8

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

1312-4-42

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Scrubber

CS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

82736

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 05/04/2012 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 20/04/2012 **Req'd Qty:** 6.00 ***6***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Form using D3256-1T2

140

140

QC5- Inspect part completeness to step on W/O

0.00.

QC

Memo

0.00

Quality Control

150

150

Identify as per dwg & Stock Location: 187

0.00

Packaging

Memo

0.00

Packaging

Dart Aerospace Ltd

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Work Order ID 82736***82736***

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Item Name: Panel

Stop ***NS2***

Start Date: 05/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/5/16 *[Signature]*
MF
12-05-15

W/O:		WORK ORDER CHANGES					
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Picklist Print

April-05-12 12:57:18 PM

Page 1

Work Order ID: 82736

82736

Parent Item: D3256-1

D3256-1

Parent Item Name: Panel

Start Date: 05/04/2012

Required Date: 20/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-09-28 EC verified by:DD
IPP Rev:b ECN 1052 07-10-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S22GA		Purchased	No			100	sf	141.9000	0.987	6.233684			
-----------	--	-----------	----	--	--	-----	----	----------	-------	----------	--	--	--

M304S22GA

304/316 .032 Sheet

**

8.
1812-4-12

Location

Loc Qty

Loc Code

MAT020

141.9

118271

12.9

120866

129

120866

(8)

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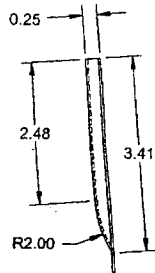
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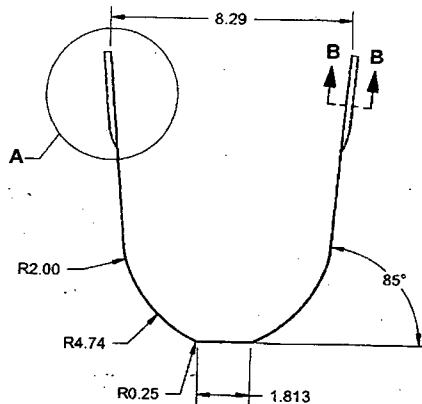
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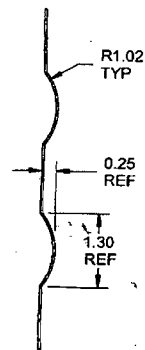
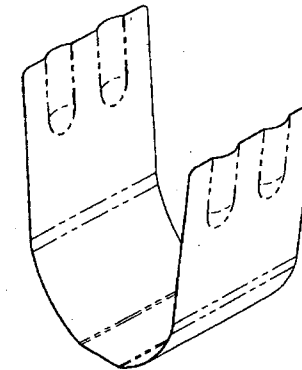
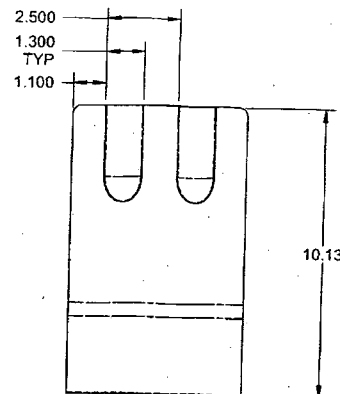
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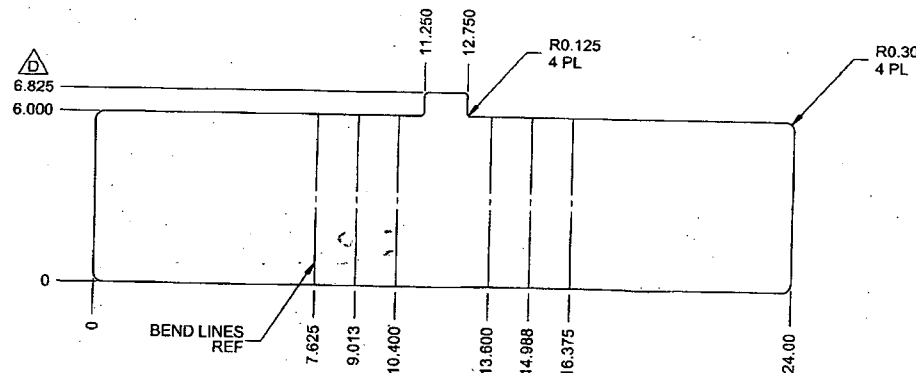
DETAIL A
SCALE 2X



D3256-1 ACCESS PANEL
(MAKE FROM D3256-1F)



SECTION B-B
SCALE 2X
(VIEW ROTATED)



D3256-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 0.032 THICK PER MIL-S-5019 OR AMS 5513/AMS 5524 OR ASTM A240 OR ASME SA240 REF. DART SPEC. M304S22GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3256-1" AND B/N "BXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 1.37 lbs

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 82736 MLU
12/04/05

RELEASE
R 2011-11-10

D	UPDATED TO COMPLY WITH QSI 043; REMOVED "FORM JOGGLE PER D3256-1T1" AND "FORM PER D3256-1T2" (SEE PREVIOUS REV FOR REFERENCE); 6.825 WAS 6.450 (ZN B7-1); 0.83 WAS 0.45 (ZN C6-2). REASON: PART 11-124.	MB	11.10.25
C	D3256-041 ELIMINATED: REMOVED (QTY 22) 0.128 HOLES FROM D3256-1F AND D3256-3 GASKET. INSTRUCTIONS TO DRILL HOLES AND INSTALL D3256-3 GASKET ARE NOW PART OF THE INSTALLATION INSTRUCTIONS	MB	07.09.28
B	D3256-3 DIM 1.30 WAS 0.65	RF	05.06.27
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	#		
DRAWN	#		
CHECKED	#		
MFG. APPR.	#		
APPROVED	#		
DE APPR.	#		
DATE	11.10.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3256** REV. D
SHEET 1 OF 2
TITLE **ACCESS PANEL** SCALE NTS

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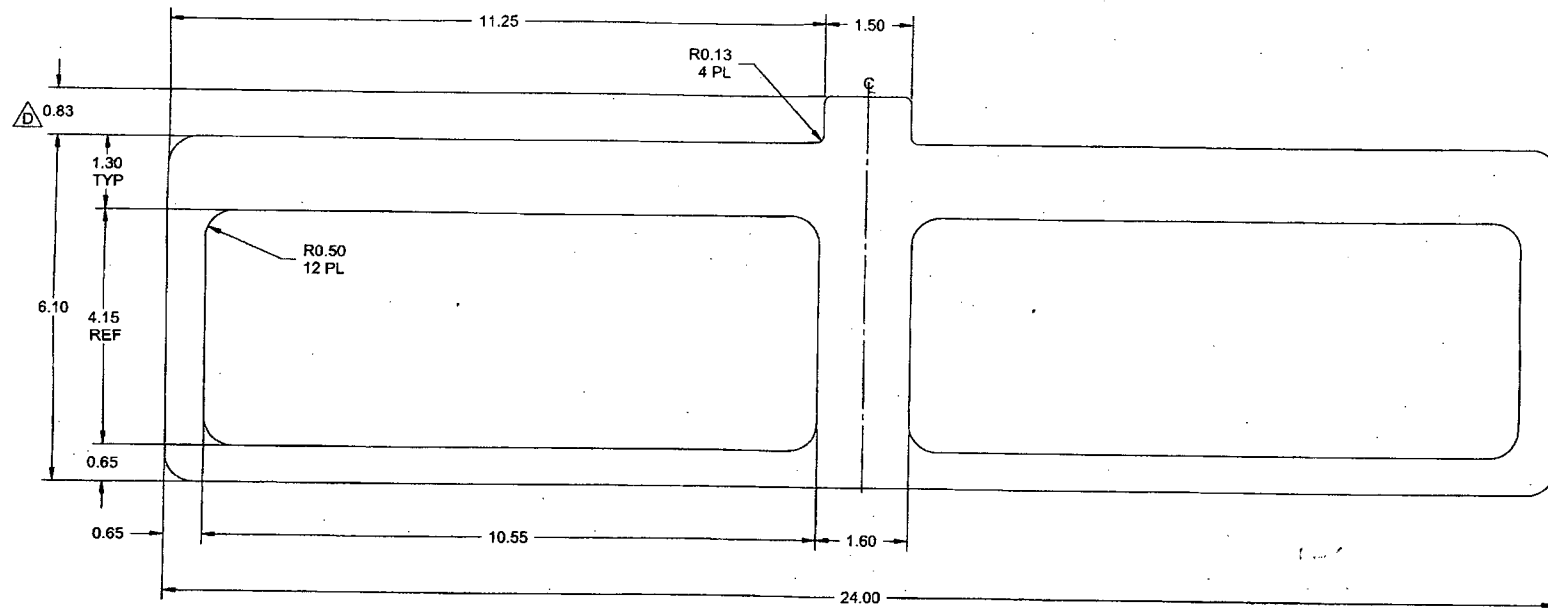
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82736



D3256-3 GASKET

RELEASE
2011-11-10
W

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET 0.035 THICK
PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A OR AMS 3232
REF. DART SPEC. MDURAS.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN		DART AEROSPACE LTD.	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3256	REV'D
MFG. APPR.		TITLE	SHEET 2 OF 2
APPROVED		ACCESS PANEL	SCALE
DE APPR.			UNITS
DATE	11.10.25		

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